

# Work Order ID 73553

Friday, September 02, 2011 9:04:04 AM

Page 1

Item ID: D2144

Accept

Revision ID:

Item Name: Hinge Bracket

Start Date: 9/2/2011 Start Qty: 10.00

Required Date: 9/13/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:                      Date:                     

QC:                      Date:                     

Tooling:                      Date:                     

SPC (Y/N):                      Date:                     

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D2144 Rev D

100 0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2144 Dwg Rev: D Prog Rev: D 12-

Deburr if necessary

304 . 053

B11-9-13

26

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-9-13

120 0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/14/14

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73553

Friday, September 02, 2011 9:04:04 AM

Page 2

Item ID: D2144

Accept

Revision ID:

Item Name: Hinge Bracket

Start Date: 9/2/2011 Start Qty: 10.00

Required Date: 9/13/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur if necessary

0.00

0.00

u/AS

140



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D2144Rev: 1

0.00

0.00

SB 11/6/12

22

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S. 11/6/12

726

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73553

Friday, September 02, 2011 9:04:04 AM



Item ID: D2144

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 9/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/13/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld corner as per Dwg D2144 & QSI 004; 2- Grind flush

MM 4509-

26 11-09-21 JBL

Pro →

170

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

11-09-21 Good (x25) (1x) SCRAP

180

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8/10/11

Good (x25) (1x)

W/O: 73553		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2144 PAR #: 1/7 Fault Category: Page FAB NCR: Yes No DQA: 18 Date: 11.09.29  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/09/29

NCR: 11-865		WORK ORDER NON-CONFORMANCE (NCR) 20.74						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/21	160	Qty x1 SCAP. welder Didn't follow Day and welder up the corner RC. LOA. (Day is clean)	U 11/09/21 PER DST	-Scrap + Destroy Qty x1 no replace extra made	11-09-21 JDL	S 11/09/21	U 11/09/21	S 11/09/21

NOTE: Date & initial all entries

# Work Order ID 73553

Friday, September 02, 2011 9:04:04 AM

Page 4

Item ID: D2144

Accept

Revision ID:

Item Name: Hinge Bracket

Start Date: 9/2/2011 Start Qty: 10.00

Required Date: 9/13/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

200

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

210

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

25x 11/04/22

25. 11/04/22

11/12/22 250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 73553

Friday, September 02, 2011 9:04:04 AM



Page 5

Item ID: D2144

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 9/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 *[Signature]*  
MF 11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 02, 2011 9:04:01 AM

Page 1

Work Order ID: 73553



Parent Item: D2144

Parent Item Name: Hinge Bracket

Start Date: 9/2/2011

Required Date: 9/13/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: D 04.05.06 Reformat: KJ/RF  
IPP Rev:E Now on Waterjet 06-10-15 JLM:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		120	sf	94.1000	0.0945	0.945	2.5		



304/316 Sheet .063

B119-13

## Location

## Loc Qty

## Loc Code

MAT020

81.5

118578

81.5

MAT021

12.6

118217

12.6

118217



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 73553
<b>Description:</b> Hinge Bracket		<b>Part Number:</b> D2144
<b>Inspection Dwg:</b> D2144	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.383	✓		V HB07	
3.022	+/-0.010	3.022	✓		V	
2.468	+/-0.010	2.469	✓		V	
1.913	+/-0.010	1.912	✓		V	
1.555	+/-0.010	1.552	✓		V	
4.126	+/-0.010	4.129	✓		V	
3.465	+/-0.010	3.458	✓		V	
0.340	+/-0.010	.337	✓		V	
0.625	+/-0.010	.625	✓		V	
1.000	+/-0.010	1.003	✓		V	
1.083	+/-0.010	1.083	✓		V	
1.660	+/-0.010	1.660	✓		V	
2.312	+/-0.010	2.309	✓		V	
2.844	+/-0.010	2.844	✓		V	
3.294	+/-0.010	3.291	✓		V	
Ø0.257	+0.006/-0.001	.258	✓		V	
Ø0.171	+0.005/-0.001	.173	✓		V	
Ø0.320	+0.006/-0.001	.322	✓		V	
0.354	+/-0.010	.347	✓		V	
0.063	+/-0.010	.058	✓		V	

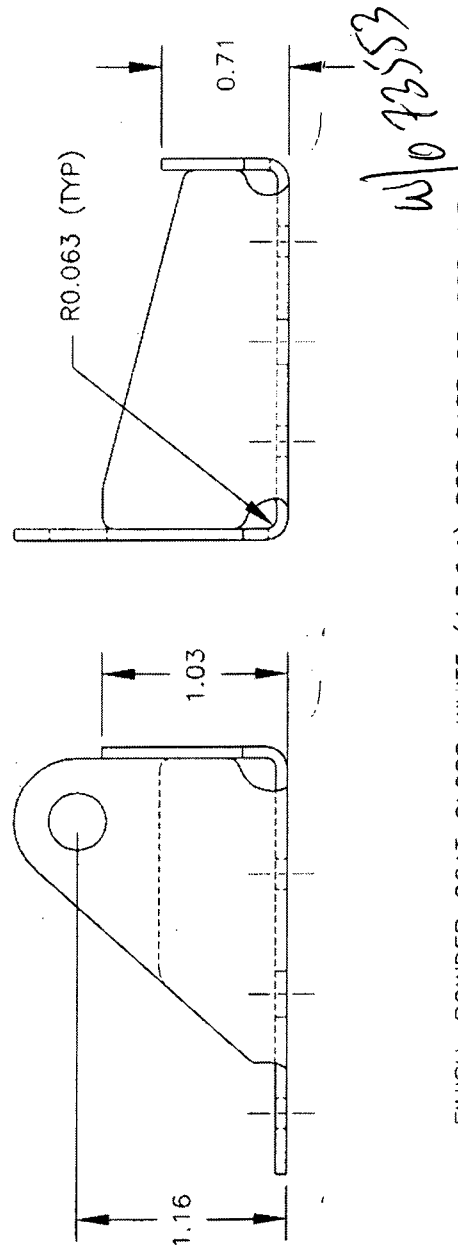
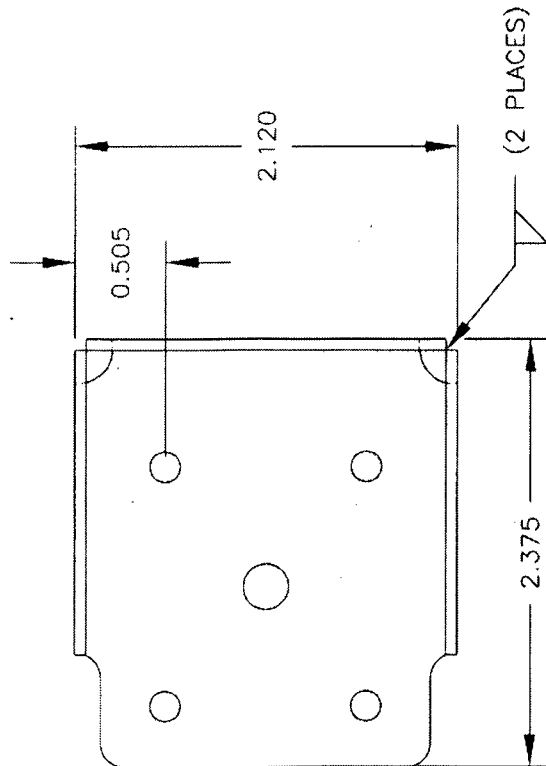
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-9-13	<b>Date:</b> 11-9-14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MA	APPROVED CA	DRAWING NO. D2144	REV. D SHEET 1 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

RELEASED  
98.10.08 KE

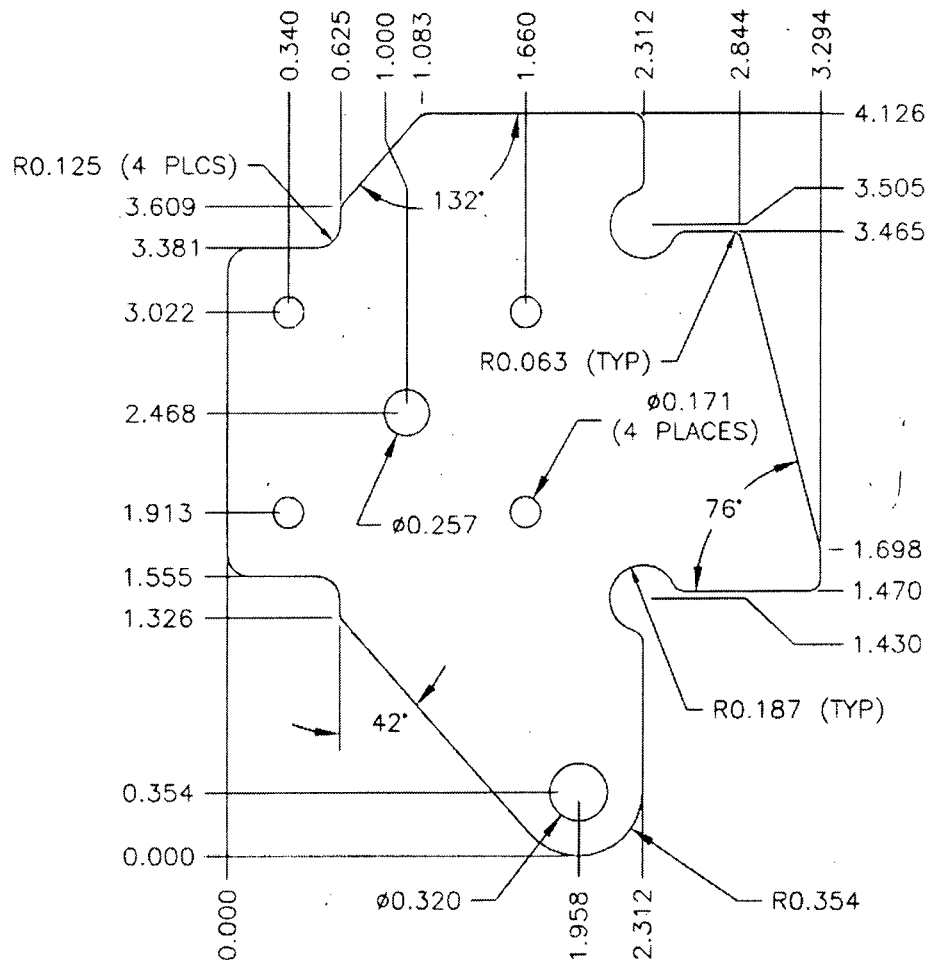


FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED VLA	APPROVED QS	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED  
98.10.15 KE



### D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES